

Date: Wednesday, 7/11/2007 2:49:04 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 33488
 Estimate Number : 10009
 P.O. Number : N/A Part Number : D27351
 This Issue : 7/11/2007 S.O. No. : N/A Drawing Number : D2735 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : 32770 Material : N/A
 Due Date : 7/31/2007 Qty: 30 Um: Each
 Written By :
 Checked & Approved By : [Signature]
 Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM
 est rev D waterjet 06.09.19 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S125 1010-1025 sheet .125



Comment: Qty.: 0.1733 sf(s)/Unit Total: 5.1975 sf(s)
 1010-1025 sheet .125

M105034 => SAD 07/08/03

07/11/2007 Patch: M103433

LB 07-07-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2735 (D2735-1)
 Dwg Rev: C
 Prog Rev: C

SAD 07/08/08

2-Deburr if necessary

LB 07-07-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/07/23

counted
(30)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204
 2-Deburr if required.

SAD 07/10/06

counted

SAD 07/10/01 (30)
burn 07/07/24 (30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2735-1 PAR #: WA Fault Category: Prod / Eng. Ass ^{med & small} NCR: Yes No DQA: 2 Date: 07/11/06
 QA: N/C Closed: 2 Date: 07.11.06

NCR: <u>33488</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-07	5.0	All parts scrap. Parts were not bent correctly. The angle bend was not performed before the Radius bend, which resulted in a bad fit. Also due to a chip in the DT 8204 die, deep gouges were made in the lugs across the holes. Root cause: Human error: improper bending process	<i>[Signature]</i>	Scrap & destroy all Qty 30 Replace on the water jet and Rebar Level Hand in G.A. to train employee on bend process Remove markings from DT 8204	FF 07-08-08 340 07/09/08 SB	Er Chide	<i>[Signature]</i>	07-08-08

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 33488

Part Number: D27351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

07/10/09 (30)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/11/05 (30)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/06

Job Completion



07/11/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

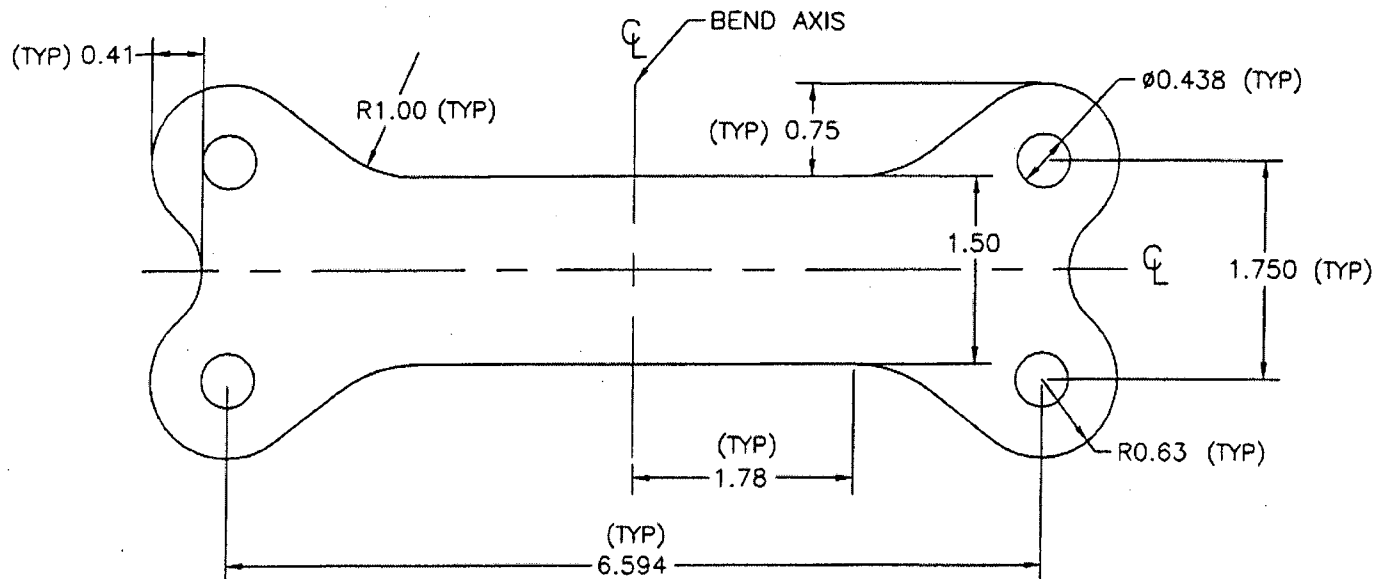
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

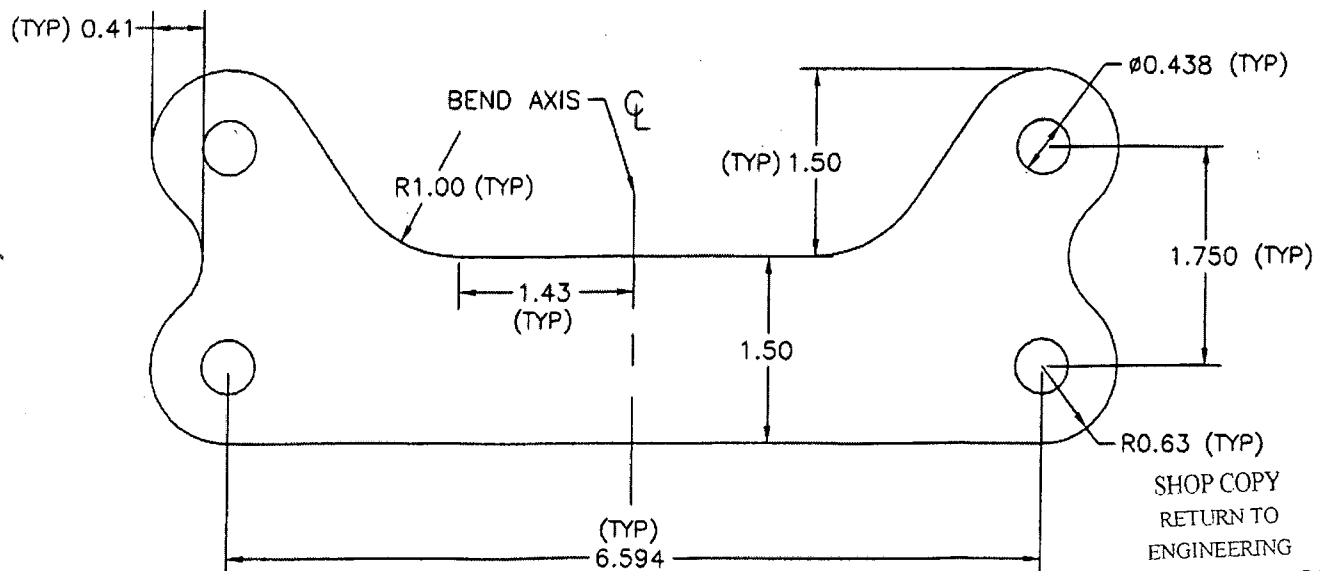


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



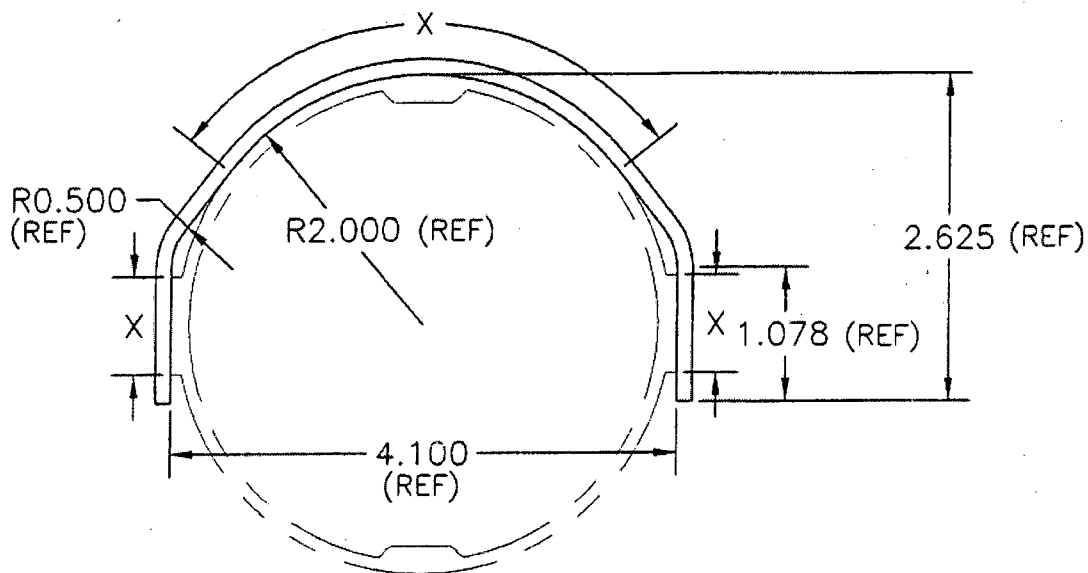
D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33488



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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NO. 33488

DART AEROSPACE LTD		Work Order:	33488
Description: Lug Bracket		Part Number:	D2735-1
Inspection Dwg: D2735 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: <u>SAD</u>	Audited by: <u>Sn</u>	Prototype Approval: <u>N/A</u>
Date: <u>07/08/08</u>	Date: <u>07/08/08</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	